

Date: Monday, 02/03/2009 11:25:50 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 46197-2
 Estimate Number : 12942
 P.O. Number :
 This Issue : 02/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 45195
 Written By :
 Checked & Approved By : JUD 09.03.02
 Comment : Est Rev : A New Issue 07-01-22 EC

Drawing Name : DOOR DOUBLER

Part Number : D3594044
 Drawing Number : D3594 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 16/03/2009

Qty: 8 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.5355 sf(s)/Unit Total : 4.2840 sf(s)
 6061-T6 .080 Sheet
 Batch: 111003

ml 09 03 06 (8)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3594
 Dwg Rev: B
 Prog Rev: B

2-Deburr if necessary

ml 09 03 06 (8)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 03 06 (8)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 02/03/06 (8) -4

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 C'SINK AS PER DWG D3594

P/D 09/03/09 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3594-044 PAR #: N/A Fault Category: Prod / Ins.assy met + small NCR: Yes No QDA: 1 Date: 09/03/12
 Resolution: Process - revised Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: <u>46197</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/03/09</u>	<u>5</u>	<u>1 part e sink to deep first part at the set-up</u> <u>fc: new Set-up.</u>	<u>[Signature]</u>	<u>Scrap + destroy</u>	<u>[Signature]</u> <u>09/03/09</u>	<u>SB</u> <u>09/03/09</u>	<u>[Signature]</u> <u>09/03/09</u>	<u>[Signature]</u> <u>09/03/09</u>

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:25:50 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 46197

Part Number: D3594044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/03/09

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MD/BR

09/03/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1 SB 09/03/09

9.0

MS210695

Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Anchor nuts

BATCH: M107938

52

CP 09/03/09

10.0

MS20426AD44

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Rivet

BATCH: M15541

CP 09/03/09

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

CP 09/03/09 5

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/03/09

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

9/3/10

52

59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:25:50 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 46197

Part Number: D3594044

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/10 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46197
Description: Floor Doubler, RH		Part Number: D3594-4
Inspection Dwg: D3594	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.25	+/-0.030	12.25	✓		M.T	
7.85	+/-0.030	7.848	✓		Vern	
7.313	+/-0.010	7.322	✓		Vern	
2.688	+/-0.010	2.688	✓		Vern	
Ø0.323	+0.006/-0.001	0.326	✓		Vern	
Ø0.129	+0.005/-0.001	0.133	✓		Vern	
0.359	+/-0.010	0.358	✓		Vern	
0.718	+/-0.010	0.723	✓		Vern	
0.81	+/-0.030	0.805	✓		Vern	
2.35 2.32	+/-0.030	2.32	✓		Vern	

Measured by: M.M	Audited by: S	Prototype Approval: N/A
Date: 09 03 06	Date: 09/03/06	Date: N/A

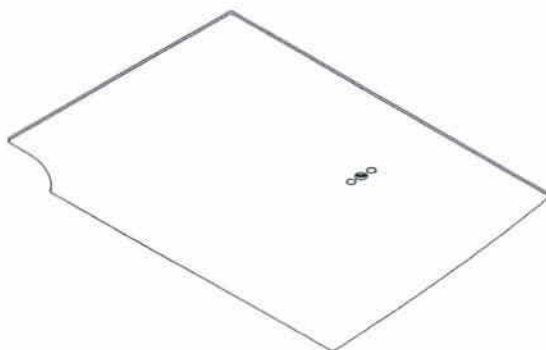
Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	EE



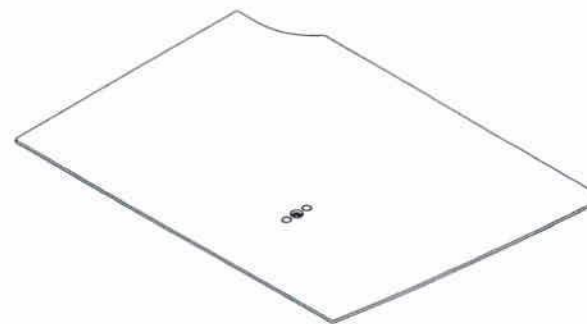
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



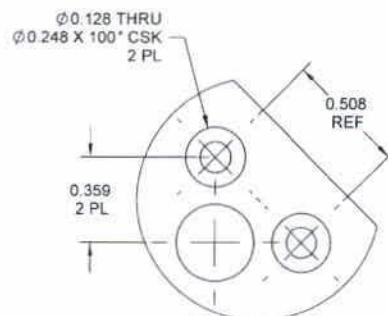
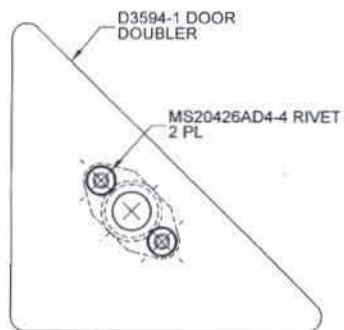
D3594-044 FLOOR DOUBLER ASSEMBLY

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08.05.14

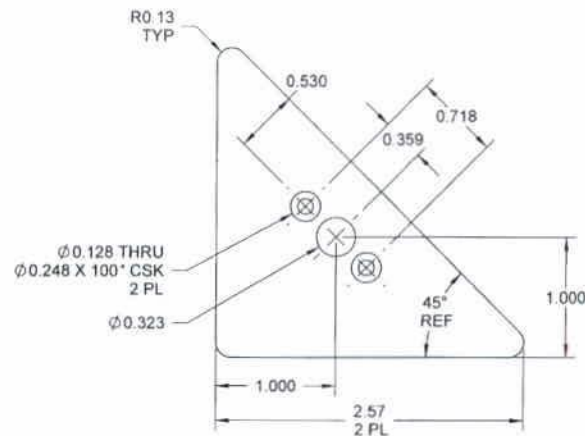
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B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3594	REV. B
MFG. APPR.		SHEET 1 OF 4	
APPROVED		TITLE DOUBLER	SCALE NTS
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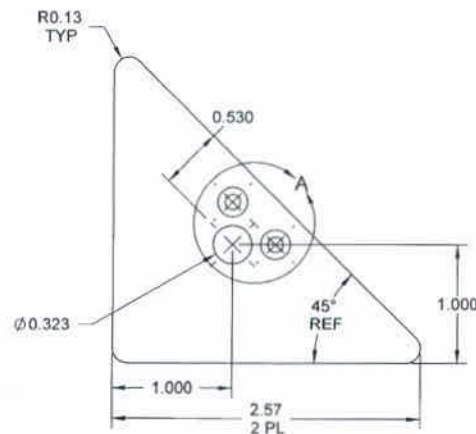
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER



D3594-5 DOOR DOUBLER

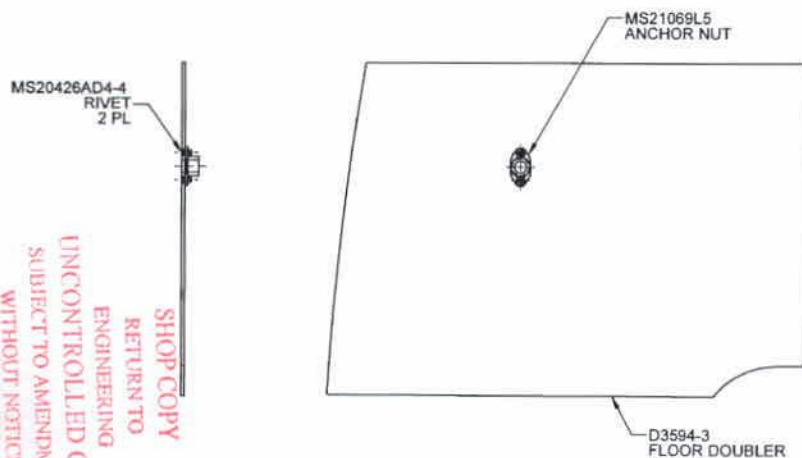
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2010-06-26

NOTES:

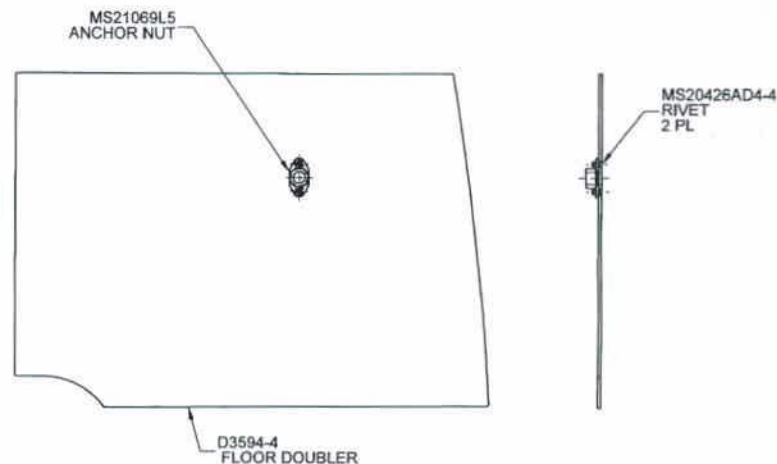
- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3594	REV. B
MFG. APPR.			SHEET 2 OF 4
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QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK






D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

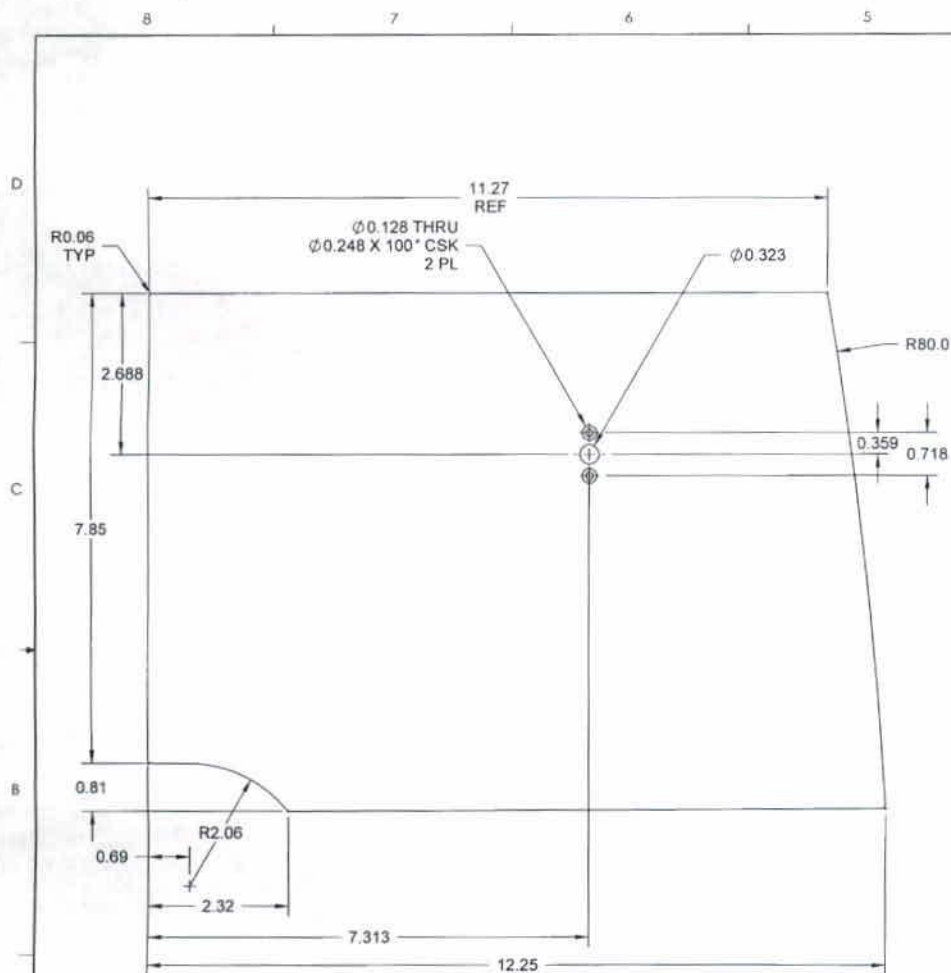
NOTES:

- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

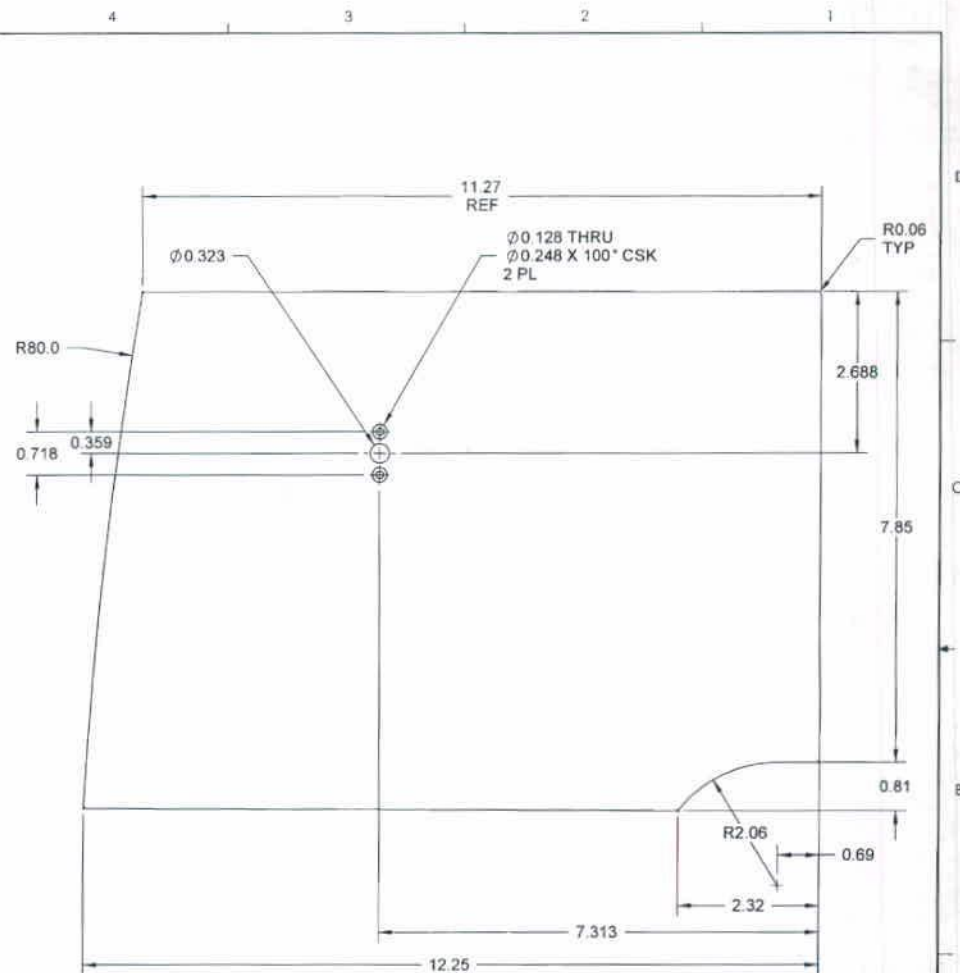
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MFG APPR.		D3594	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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08-06-14

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D3594-3 FLOOR DOUBLER



D3594-4 FLOOR DOUBLER

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11/2/97

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CHECKED		DRAWING NO. D3594	REV. B
MFG. APPR.		SHEET 4 OF 4	
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